

Work Order ID 64849

Friday, December 17, 2010 1:05:05 PM



Page 1

Item ID:	D4035-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Lid Rib Assembly, Fwd (350 Basket)					
Start Date:	12/17/2010	Start Qty:	2.00			
Required Date:	12/22/2010	Req'd Qty:	2.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:		Date:	10-12-17	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4035	A								

100	Weld per dwg A/R S.S. rod Batch: <u>M119649</u>	0.00							
Large Fab	Memo	0.00							
Large Fab	1- Cut D4035-1 as per dwg D4035								
	2- Drill as per dwg D4035 using DT9562								
	3- remove identification marks and deburr								
	4- Weld bushing in rib as per dwg D4035								

② LS 11/01/13 ②

SAD 11-01-11

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

Cpl 11-01-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64849

Friday, December 17, 2010 1:05:05 PM



Page 2

Item ID: D4035-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 12/17/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



0.00

QC

Memo

Quality Control

Subtotal

(22)

130

Identify as per dwg & Stock Location: _____

0.00



0.00

Packaging

Memo

Packaging

LY 11/01/13 (22)

140

QC21- Final Inspection - Work Order Release

0.00



0.00

QC

Memo

Quality Control

11/01/17

11/01/14

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Picklist Print

Friday, December 17, 2010 1:05:09 PM

Page 1

Work Order ID: 64849

Parent Item: D4035-041

Parent Item Name: Lid Rit Assembly, Fwd (350 Basket)

Start Date: 12/17/2010


Required Date: 12/22/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC
IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2327-3  Spacer Bushing		Manufactured	No			100	Each	13.0000	1	2		11/01/13	
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Location	Loc Qty	Loc Code
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WA	13	
58974	1	
60320	1	
64048	11	

M304TS0.750W.049  304 SQ Tube .75x.75x.049W		Purchased	No			100	f	187.8119	1.75	3.684211		SAD 10-01-12	
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Location	Loc Qty	Loc Code
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MAT	135.9156679	
113763	0	
114323	8.15031894	
114677	0.00001	
114835	0.000039	
116319	127.7653	
MAT017	3.68448E-05	
114298	3.6845E-05	
WA	51.8962	
114992	18.6511	
115260	33.2451	

3.6842

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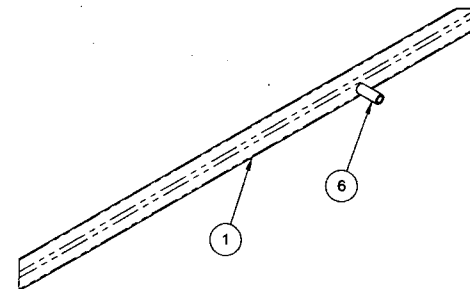
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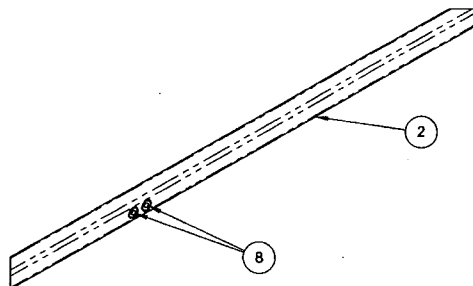
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64849

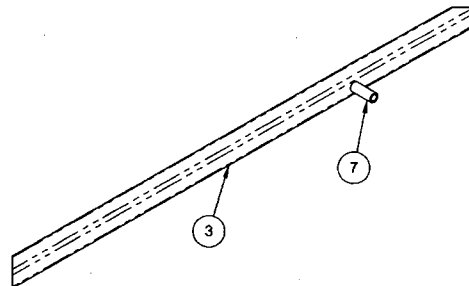
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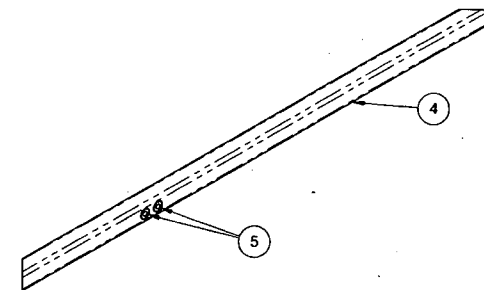
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12
AW

A	NEW ISSUE		JPH	10.03.04
REV.		DESCRIPTION	BY	DATE
DESIGN	AJS			
DRAWN	JPH			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.03.04			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4035	REV. A SHEET 1 OF 5
TITLE BASKET LID RIB ASSY	SCALE NTS
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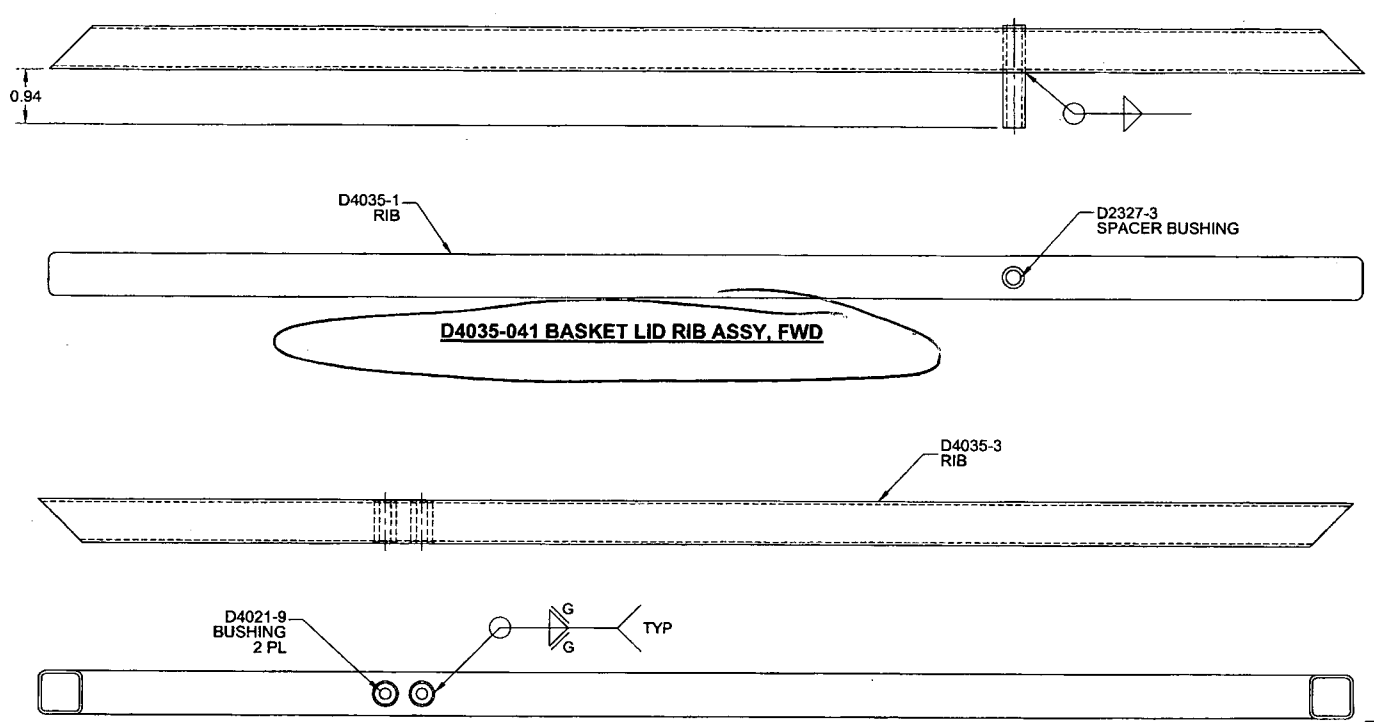
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NOTE: Date & initial all entries

u/b 44849



RELEASED
2010-03-12

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.83 lbs
 - 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
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alo 64849

D4035-5
RIB

D2953-175
SPACER

0.94

D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

D4035-7
RIB

D4035-11
BUSHING
2 PL

TYP

D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 3 OF 5
APPROVED		TITLE	SCALE
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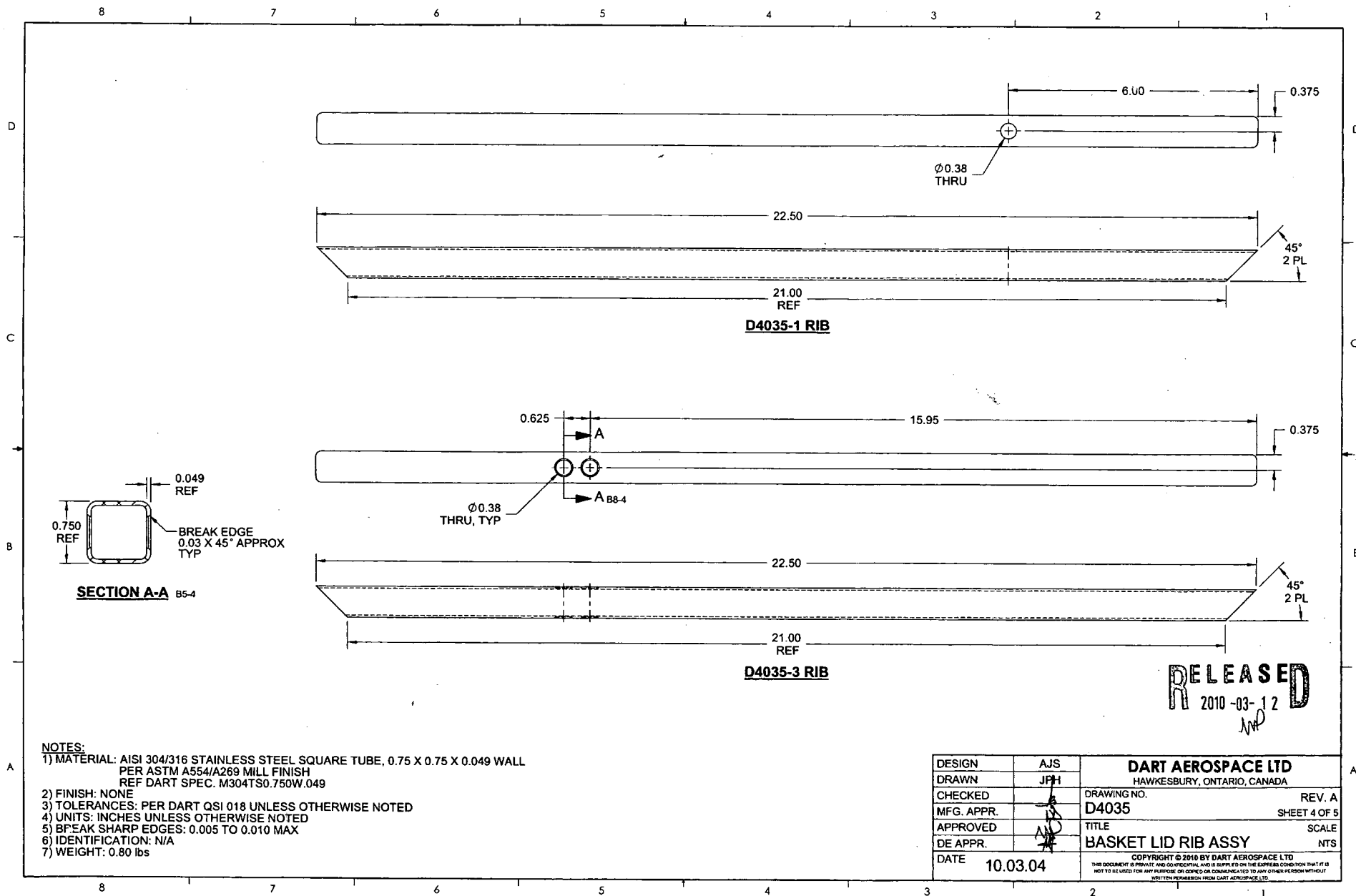
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W/O 64849



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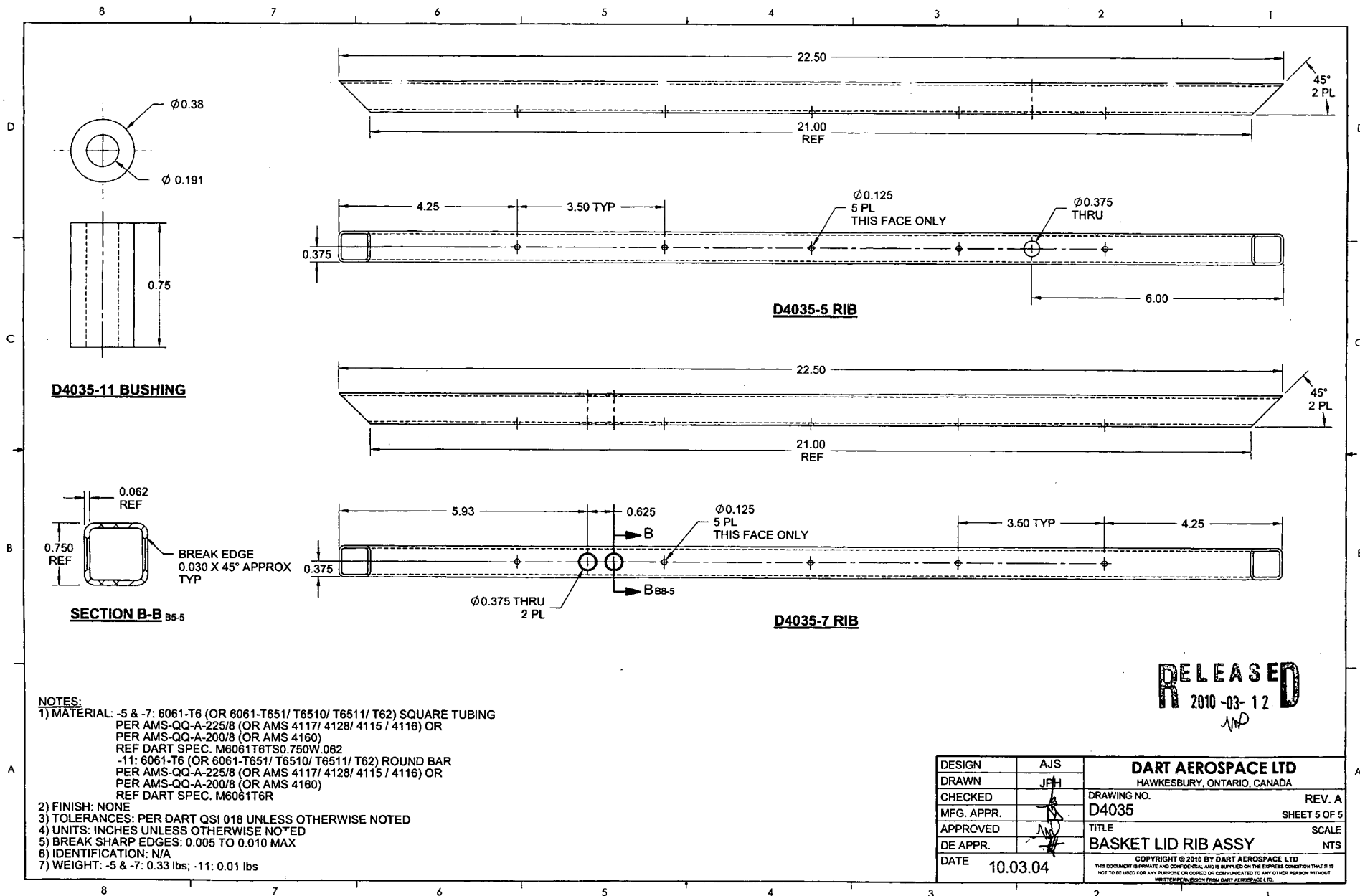
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w/o 44849



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